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D117-762-041
Job Sheet 183543



Part No: D117-762-041

Job Qty: 1 ea

Part Name: Replacement Skidtube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/20/18

Job Tracking No:

Due Date: 10/19/18

Created By: Jesse White

Type: Stock

Description: siop

Note: DWG D3582 REV E IPP Rev:A 07.06.11 New Issue EC IPP Rev:B 08-02-22 change to revA as per dwg DD
verF by:EC IPP REV:C 15.06.11 AS PER CHG002 DD VERF:JLM IPP REV:D 16.02.05 DWG REV:C (616-
514) DD VERF:JLM IPP REV:E 17.01.17 as per dwg REV.D DD VERF:JLM

Ship Via:

Bill of Materials



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Container No: S113797



Part: D117-762-041

Job No: 183543

Serial No/Batch: S113797

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SR01853SE 15/10/20 TC STC LoA RI

DART
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Container No: S113797



Part: D117-762-041

Job No: 18533

Serial No/Batch: S113797

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SR01853SE 15/10/2016 TC STC LoA RDIMS-4374899 08/0

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		10/19/18	0.00	0.00	Start Up Skid tubes-1		BR
130	Skid tubes	1 pcs		10/19/18	0.00	3.47	Skid tubes-1		BR
140	Skid tubes	1 pcs		10/19/18	0.00	3.47	Skid tubes-1		BR
150	QC	1 pcs		10/19/18	0.00	0.00	QC10		BR DAS 38
160	QC	1 pcs		10/19/18	0.00	0.00	QC5		9-89 38
170	HandFinish	1 pcs		10/19/18	0.00	0.97	HandFinish1		DR 18/09/18
180	QC	1 pcs		10/19/18	0.00	0.00	QC7-1		BR
190	Skid tubes	1 pcs		10/19/18	0.00	3.47	Skid tubes-1		BR DAS
200	QC	1 pcs		10/19/18	0.00	0.00	QC10		38 DAS
210	QC	1 pcs		10/19/18	0.00	0.00	QC5		9-89 38
215	HandFinish	1 pcs		10/19/18	0.00	0.97	HandFinish2		BR 18-10-13
220	Powdercoat	1 pcs		10/19/18	0.00	0.26	Powdercoat1		BR 18-10-13
230	QC	1 pcs		10/19/18	0.00	0.00	QC3		BR 18-10-13
250	HandFinish	1 pcs		10/19/18	0.00	0.97	HandFinish4		BR 18-10-13
260	QC	1 pcs		10/19/18	0.00	0.00	QC5		DAS 6 OCT 16 2018 68
270	Packaging	1 pcs		10/19/18	0.00	0.00	Packaging3-1		9-89 21 OCT 16 2018 9-89
275	DC	1 pcs		10/19/18	0.00	0.00	DC		21 OCT 16 2018
280	QC21-FG	1 Ea		10/19/18	0.00	0.00	QC21		21 OCT 16 2018

Part Op 130 - 1-Cut Aft end using DT8185 2-Deburr ends 3-Drill Aft Cap holes using DT8678 *** OPEN AFT CAP HOLE TO 1.875
 Descriptions: *** 4-Locate DT 8973 from aft cap holes & Drill Ground wire hole on top of Tube. 5-Install 3/16 cleco in Ground wire hole ,then drill all X-Bolt holes using 3/16" drill. 6-Drill pilot holes for wearplates using DT8900 7-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3582. 8-Drill holes for D5520-1 doubler using DT10309 A & B, locating from 4th and 5th crossbolt holes from aft using .1875 clekos. Spot drill tube using #20 drill (note 10). Remove DT10309 B. Re-install DT 10309 A drill thru tube and doubler using #20 drill (note 10), cleco as you go. Remove .1875 clekos and open holes in tube and doubler to 0.750". Remove doublers and identify orientation. 9-Deburr doubler and doubler holes in skid tube. 10-Countersink doubler holes in skid tube as per Dwg. detail J and note 12 -Touch up alodine on D5520-1 doublers. 11- open ground wear holes to 0.391" as per section B-B 12-Open Aft Cap holes using .209" drill. 13-Drill pilot holes for section D-D and E-E. Holes must be laid out by hand. Mark out Center line and make sure that 6.65 and 5.906 measurements are respected. Double check before drilling, do not open holes to finish size. 12-Do not open holes of section G-G to finishes size.

140 - 1-Weld fwd cap D2964 per dwg D3582 and QSI 004 A/R AL ROD Batch: 138673 2-Grind flush

190 - ***MASK OFF HOLES OF SECTION F-F (DO NOT C'SINK) 1-Open X-Bolt holes to finish size as per Dwg D3582, sections D-D, E-E, G-G as per Dwg. 2-Counter Sink X-BOLT holes as per Dwg D3582 D-D, E-E and G-G.***Do NOT countersink holes of section F-F). 3-Deburr and blow out chips from inside of tube, prep. tube for welding. 4-Install doublers using DT10309 B. Shave rivets as required. 5-Bond web as per Dwg D3582 & QSI 015 A/R 241 Sika Flex Batch: m138943 Exp Date: MAR 06 2019 6- Swage x-bolt spacer as per dwg and Section F-F QSI002. 7-Weld x-bolt spacers as per Dwg D3582 section D-D, E-E and G-G. A/R AL ROD Batch: 130165 8-Grind welds flush

215 - Touch-up alodine as per QSI

220 - START TIME 11:40 OVEN TEMPERATURE: 320° FINISH TIME: 12:10

250 - 1-Inspect for Foreign objects 2-Install Aft cap as per Dwg D3582, Detail "C" A/R 241 Sika Flex Batch: m138943 Exp Date: 08-3 3-Install Wearplates as per Dwg D3582 , Note:Install Bolt and washer on Ground Wire inserts on top of tube see section D-D of dwg D3582 *****Do not install bolts where indicated on Dwg(Note #6)***** 4- Wing Walk as per Dwg D3582 and QSI 005 4.4

270 - Identify and pack for shipping as per PPP D117-762-041 Location :FG081

275 - Photocopy bluefile & type labels per PPP D117-762-041 CHG003

005922

S113768

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3582-1-BENT	Skidtube Assembly BK117	1 Ea (1 ea)	90-Start up Operation	5108445
D5520-1	Doubler	2 Ea (2 ea)	130-Skidtubes	5082767
D2964	Cap	1 Ea (1 ea)	140-Skidtubes	5077380
CR3212-5-05	Rivet	68 pcs (68 ea)	190-Skidtubes	5089456
D2971	Cross Bolt Spacer	1 Ea (1 ea)	190-Skidtubes	5097024
D3584-1	Web	1 Ea (1 ea)	190-Skidtubes	5106746
D3662-1	Crossbolt Spacer	3 Ea (3 ea)	190-Skidtubes	5108712
D3662-3	Crossbolt Spacer	1 Ea (1 ea)	190-Skidtubes	F81606
D5304-1	Crossbolt Spacer	2 Ea (2 ea)	190-Skidtubes	5093587
ALS4-1032-130	Rivnut	36 Ea (36 ea)	250-HandFinish	5087776
ALS4-428-165	Insert	2 Ea (2 ea)	250-HandFinish	5058145
AN3-5A	Bolt	2 Ea (2 ea)	250-HandFinish	5095480
AN3C4A	Bolt	28 Ea (28 ea)	250-HandFinish	5096223
AN4-4A	Bolt	2 Ea (2 ea)	250-HandFinish	5104458
D2965	Cap	1 Ea (1 ea)	250-HandFinish	5045482
D3508-11	Wearplate Aft Center	1 Ea (1 ea)	250-HandFinish	5057791
D3508-13	Wearplate Aft	1 Ea (1 ea)	250-HandFinish	5045060
D3508-3	Wearplate Fwd Center	1 Ea (1 ea)	250-HandFinish	5045066
D3508-9	Wearplate Fwd	1 Ea (1 ea)	250-HandFinish	5089814
D3558-11	Gasket Aft Center	1 Ea (1 ea)	250-HandFinish	5058252
D3558-13	Gasket Aft	1 Ea (1 ea)	250-HandFinish	5088628
D3558-3	Gasket Center Fwd	1 Ea (1 ea)	250-HandFinish	5077343
D3558-9	Gasket Fwd	1 Ea (1 ea)	250-HandFinish	5088626
NAS1149C0332R	Washer	28 Ea (28 ea)	250-HandFinish	5071663
NAS1149D0332J	Washer	2 Ea (2 ea)	250-HandFinish	5100407
NAS1149D0416J	Washer	2 Ea (2 ea)	250-HandFinish	FNU31511

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3582-1-BENT	1	0	0
130-Skidtubes	D5520-1	2	20	0
140-Skidtubes	D2964	1	5	0
190-Skidtubes	CR3212-5-05	68	405	0
	D2971	1	34	0
	D3584-1	1	8	0
	D3662-1	3	18	0
	D3662-3	1	27	0
	D5304-1	2	27	0
250-HandFinish	ALS4-1032-130	36	12,174	0
	ALS4-428-165	2	52	0
	AN3-5A	2	307	0
	AN3C4A	28	2,349	0
	AN4-4A	2	71	0
	D2965	1	50	0
	D3508-11	1	5	0
	D3508-13	1	7	0
	D3508-3	1	4	0
	D3508-9	1	5	0
	D3558-11	1	5	0
	D3558-13	1	7	0
	D3558-3	1	8	0
	D3558-9	1	8	0
	NAS1149C0332R	28	5,311	0
	NAS1149D0332J	2	1,958	0
	NAS1149D0416J	2	2,862	0

Part Specifications

Specifications could not be found.